Work Order ID 59690

Wednesday, June 09, 2010 1:42:38 PM

Item ID: D2673-34 **Accept** **Setup Start**

Revision ID:

Item Name: End Plate **Stop**

Start Date: 6/9/2010 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 6/24/2010 **Req'd Qty:** 12.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 10-6-09 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2673	**Revision Nbr** Rev B								
100 Waterjet	FLOW WATER JET	0.00							
	Memo 1-Cut as per Dwg D2673 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary	0.00				10-6-21			
FLOW CNC Waterjet 6061 .080									
110 QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00				10-6-21			
Quality Control									
120 QC	QC8- Inspect parts - second check	0.00				counted H96			
	Memo	0.00							
Quality Control									

10/06/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WH	0.00							
Packaging	**Memo**	0.00	10.06.21			196	0		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00						10/06/22	
Quality Control									

MF 10-6-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 1:42:42 PM

Work Order ID: 59690

Parent Item: D2673-34

Parent Item Name: End Plate

Comments: IPP C□02.01.14□Removed deburr and inspect level 5□NG/EC□
IPP Rev:D Now 6061-T6 06-06-23 JLM
IPP Rev:C Now on Waterjet 07-05-28 JLM

Start Date: 6/9/2010 **Required Date:** 6/24/2010

Start Qty: 12.00 **Required Qty:** 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M6061T6S.080		Purchased	No			100	sf	156.8419	0.052	0.656842	16.		

6061-T6 .080 Sheet

Location		Loc Qty	Loc Code
MAT21		156.84193	
	113438	2.7512	
	114351	154.09073	

FB 10-6-21

(196)

114351

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39690
Description: End Plate	Part Number:	D2673-34
Inspection Dwg: D2673 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.300	+/-0.010	3.304	✓			
2.247	+/-0.010	2.250	✓			
R0.250	+/-0.010	.250	✓			

Measured by:	RB
Date:	10-6-21

Audited by:	S
Date:	10/06/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

Dart Aerospace Ltd

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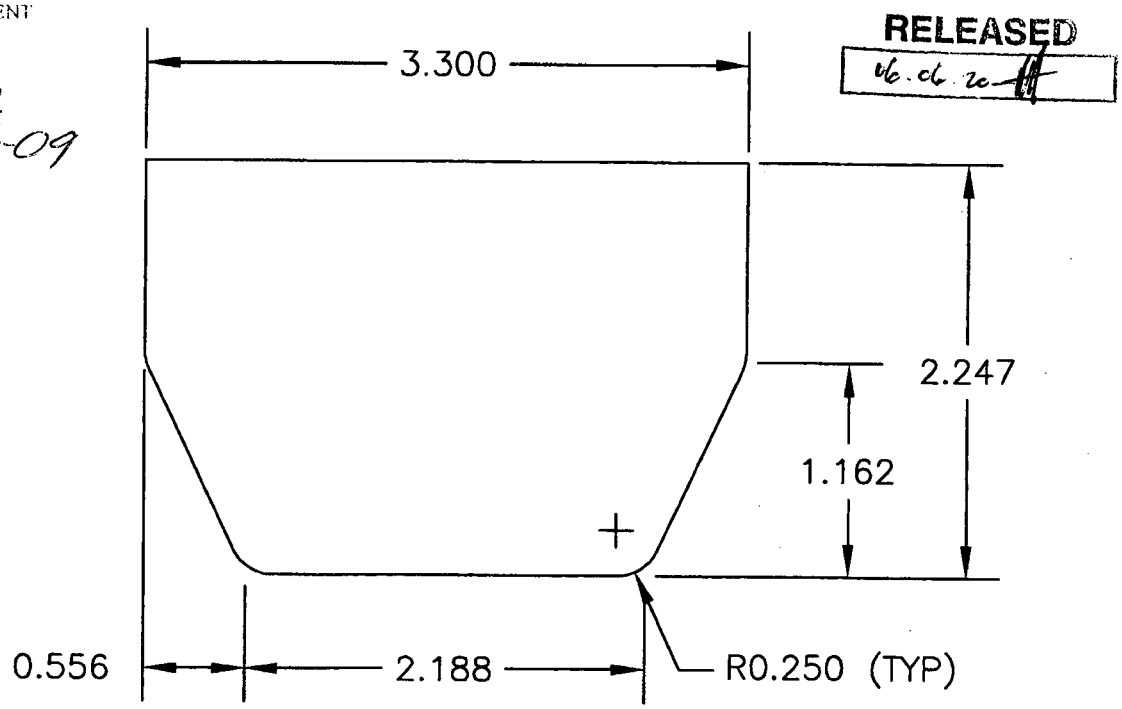
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	CB		
CHECKED: PH	APPROVED	DRAWING NO.: D2673	REV. B SHEET 1 OF 1
DATE: 06.05.29		TITLE: END PLATE	SCALE: 1:1

A	97.05.06	NEW ISSUE
B	06.05.29	ADD 6061–T6 MATERIAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
PO. 599190
PP 10-6-09

RELEASED
06.06.20

END PLATE FOR D2244 EXTRUSION CUT AT 34°



D2673–34

NOTES:

1) MATERIAL: 6061–T6 (PER QQ–A–250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052–H32/H34 (PER QQ–A–250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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